

Work Order ID 151442

Tuesday, September 27, 2016 11:53:37 AM

151442

Page 1

Item ID: D117-762-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube with Standard Wearplates Fits LH or RH
 Start Date: 9/15/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/27/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference: **DAS 21 9-89**

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 27 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E		DAS 6 9-89						
100	Document Control								
100	DOCUMENT CONTROL								
DC	Memo	0.25							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-762-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

B151650

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 151442***151442***

Page 2

Tuesday, September 27, 2016 11:53:37 AM

Item ID: D117-762-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D117-762-011
Location :FG081DAS
27
9-89DAS
28
9-89

DEC 13 2016

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.02

DAS
21
9-89

DEC 14 2016

Quality Control

DAS
21
9-89
DAS
21
9-89

DEC 14 2016

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :	

Picklist Print

Tuesday, September 27, 2016 11:53:37 AM

Page 1

Work Order ID: 151442

151442

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/15/2016

Required Date: 9/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.06.11New Issue EC
IPP Rev:B 08-02-22 change to revA DD verified by:ec
IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD
IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP
REV:E 15.06.11 IIN REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D117-762-041		Manufactured	No			110	Each	0.0000	1	1			
D117-762-041									**	151650			DAS 26 9-89
Replacement Skidtube													
D3512-041		Manufactured	No			110	Each	6.0000	2	2			
D3512-041									**	B149918			DAS 26 9-89
Wearplate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST610		6							
				148668		6							
AN6C51A		Purchased	No			110	Each	0.0000	2	2			
AN6C51A									**	136269		DEC 07 2016	DAS 26 9-89
BOLT													
D3864-1		Manufactured	No			110	Each	36.0000	4	4			
D3864-1									**			NOV 17 2016	DAS 26 9-89
Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST055		36							
				138204		11							
				149522		25							
										3x		NOV 17 2016	DAS 26 9-89

DQA: _____ Date: _____



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 2

Work Order ID: 151442

151442

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/15/2016

Required Date: 9/27/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

110

Each

108.0000

2

2

MS21043-6

NUT

DAS
26
9-89

DAS
27
9-89

NOV 17 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

26

m134365

1

m135297

3

m135603

22

ST302

62

m134817

32

m135470

30

2x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 151442

Friday, October 28, 2016 8:32:42 AM

151442

Page 1

Item ID: D117-762-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.25							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-762-011		CHG003						
110	Pick Kit	0.00							
110	Packaging	0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC	0.00							
Quality Control	Memo								

REFERENCE ONLY**5.0 PARTS LIST****5.1 D117-762-011 Skidtube Parts List**

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*NAS1149C0332R	WASHER (OR AN960C10L)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*NAS1149C0332R	WASHER (OR AN960C10L)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*NAS1149C0332R	WASHER (OR AN960C10L)
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY
 ** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY
 *** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE